

# Work Order ID 60069

June 24, 2010 9:01:03 AM



Page 1

Item ID: D3259-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 6/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3259

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3259-041 as per Dwg D3259. Note: Keep .040" Gap all around door.

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*EP 10/07/29* (4)

*EP 10/07/29* (4)

*Siolus 29*

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60069

June 24, 2010 9:01:04 AM

Page 2

Item ID: D3259-041

Accept

Revision ID:

Item Name: Access Panel Assembly

Start Date: 6/24/10 Start Qty: 4.00

Required Date: 7/02/10 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 182

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

6/27/10 (4)

10/08/03 (4)

11-10-7-30 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 24, 2010 9:01:01 AM

Page 1

Work Order ID: 60069

Parent Item: D3259-041

Parent Item Name: Access Panel Assembly

Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV  
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3161-5		Manufactured	No			110	Each	17.0000	1	4			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Hinge 9.9"

Location

Loc Qty

Loc Code

ST040

17

43606

2

47187

3

47773

12

D3259-1		Manufactured	No			110	Each	5.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Panel

Location

Loc Qty

Loc Code

ST180

5

58749

5

D3259-3		Manufactured	No			110	Each	1.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Doubler

Location

Loc Qty

Loc Code

ST180

1

47189

1

D3259-5		Manufactured	No			110	Each	4.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Spacer

Location

Loc Qty

Loc Code

ST180

4

58750

4

EPB 10/07/29

EPB 10/07/29

B60082 (3x)

EPB 10/07/29

B60083 (3x)

EPB 10/07/29

B60084 (4x)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 24, 2010 9:01:01 AM

Page 2

Work Order ID: 60069

Parent Item: D3259-041

Parent Item Name: Access Panel Assembly

Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

D3259-7 Manufactured No

110 Each 7.0000



Door

Location

Loc Qty

Loc Code

ST180

7

58751

7

4  
EB 10/07/29  
B60085 (27)

\* D3260-1 Manufactured No

110 Each 6.0000



Spring

Location

Loc Qty

Loc Code

ST047

6

47852

6

B60087

2  
8  
EB 10/07/29  
8

\* D3972-5 Manufactured No

110 Each 11.0000



Grommet, Half, DZUS

Location

Loc Qty

Loc Code

ST107

11

58752

11

M115173

2  
8  
EB 10/07/29  
3

D3973-5 Manufactured No

110 Each 84.0000



Receptable, Rigid, DZUS

Location

Loc Qty

Loc Code

ST107

84

58759

84

2  
8  
EB 10/07/29  
8

D3974-20 Manufactured No

110 Each 90.0000



Stud, Wing Head, 5/16 DZUS

Location

Loc Qty

Loc Code

ST107

90

58761

90

2  
8  
EB 10/07/28  
8

June 24, 2010 9:01:01 AM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June 24, 2010 9:01:02 AM

Work Order ID: 60069

Parent Item: D3259-041

Parent Item Name: Access Panel Assembly

Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

MS20426AD4-4 Purchased No  
Rivet

110 Each

1,249.000

4

16

Location

Loc Qty

Loc Code

ST316

1249

15541

1249

MS20470AD3-4 Purchased No  
Rivet, Universal Head

110 Each

11,008.00

36

144

Location

Loc Qty

Loc Code

ST319

11008

111477

8332

15541

2676

MS20470AD3-5 Purchased No  
Rivet

110 Each

4,282.000

10

40

Location

Loc Qty

Loc Code

ST319

4282

104817

3030

9682

1252

CP 10/07/29

16  
CP 10/07/29

144  
CP 10/07/29

40

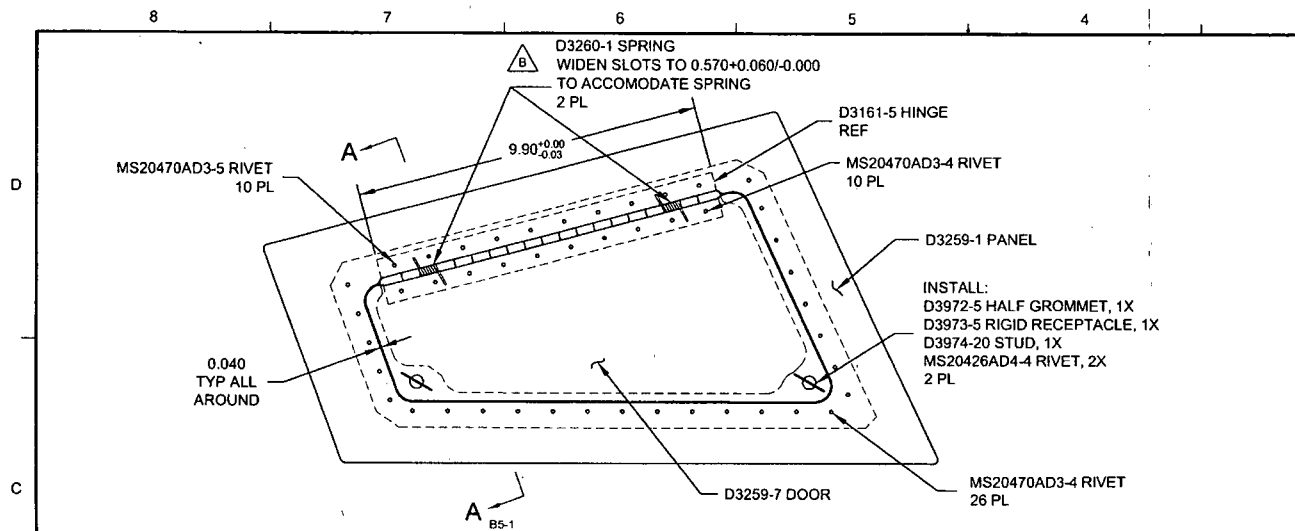
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

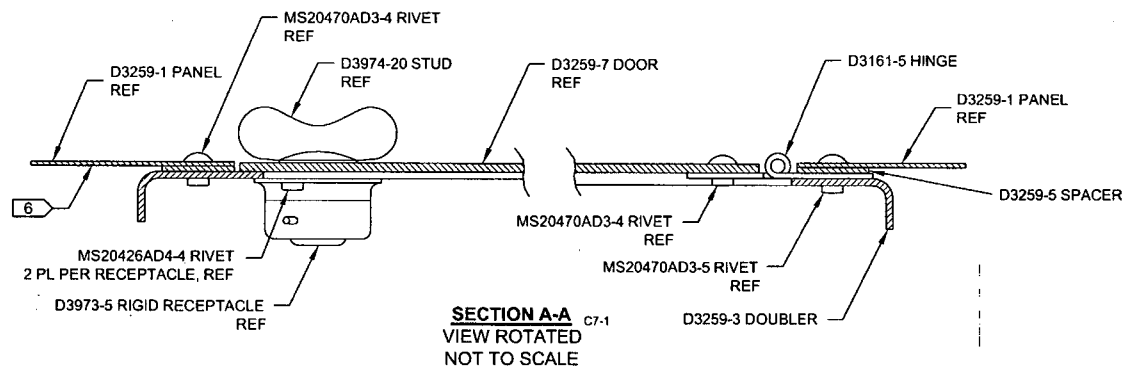
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-041	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-3	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF, DZUS
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



### D3259-041 ACCESS PANEL ASSEMBLY

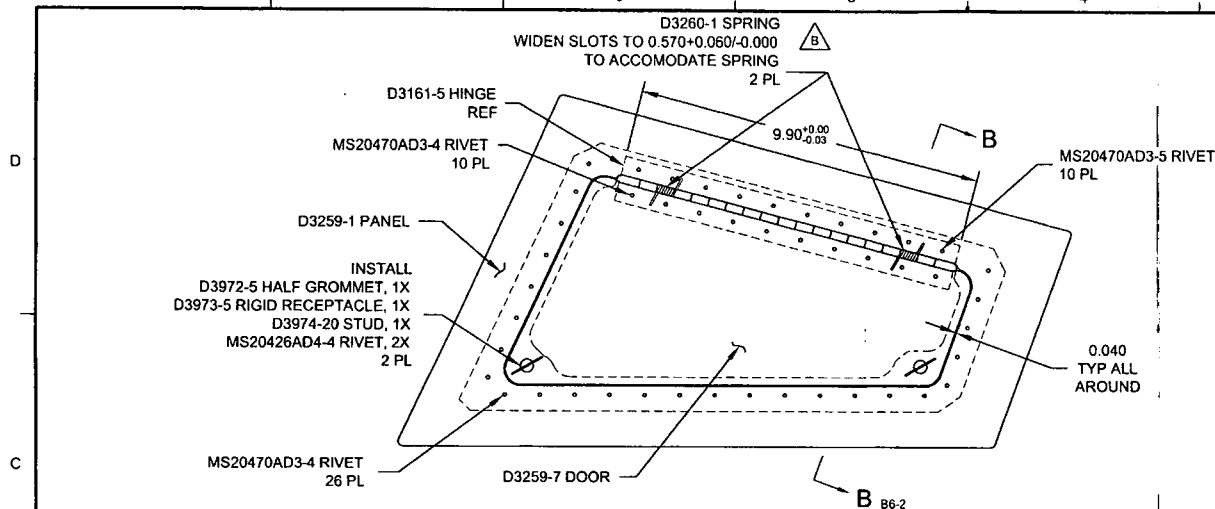
#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-041" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

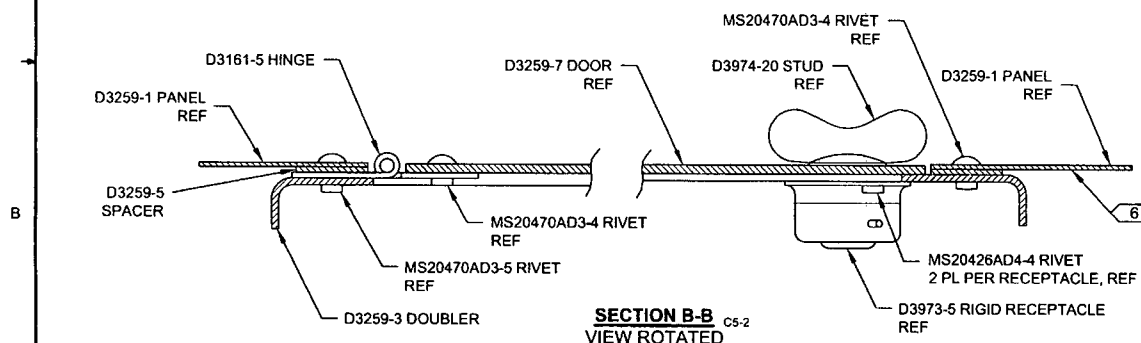
**RELEASED**  
2009-10-08

B	REFORMAT DWG, R0.25 WAS R0.18 (ZN B8-4, B1-5) -3F REDESIGN (SHT 6), WIDEN SLOTS (ZN D6-1, D5-2)	CP	09.08.12
A	NEW ISSUE	CP	04.02.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	NTS
DATE	09.08.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

8 7 6 5 4 3 2 1



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



# **D3259-042 ACCESS PANEL ASSEMBLY**

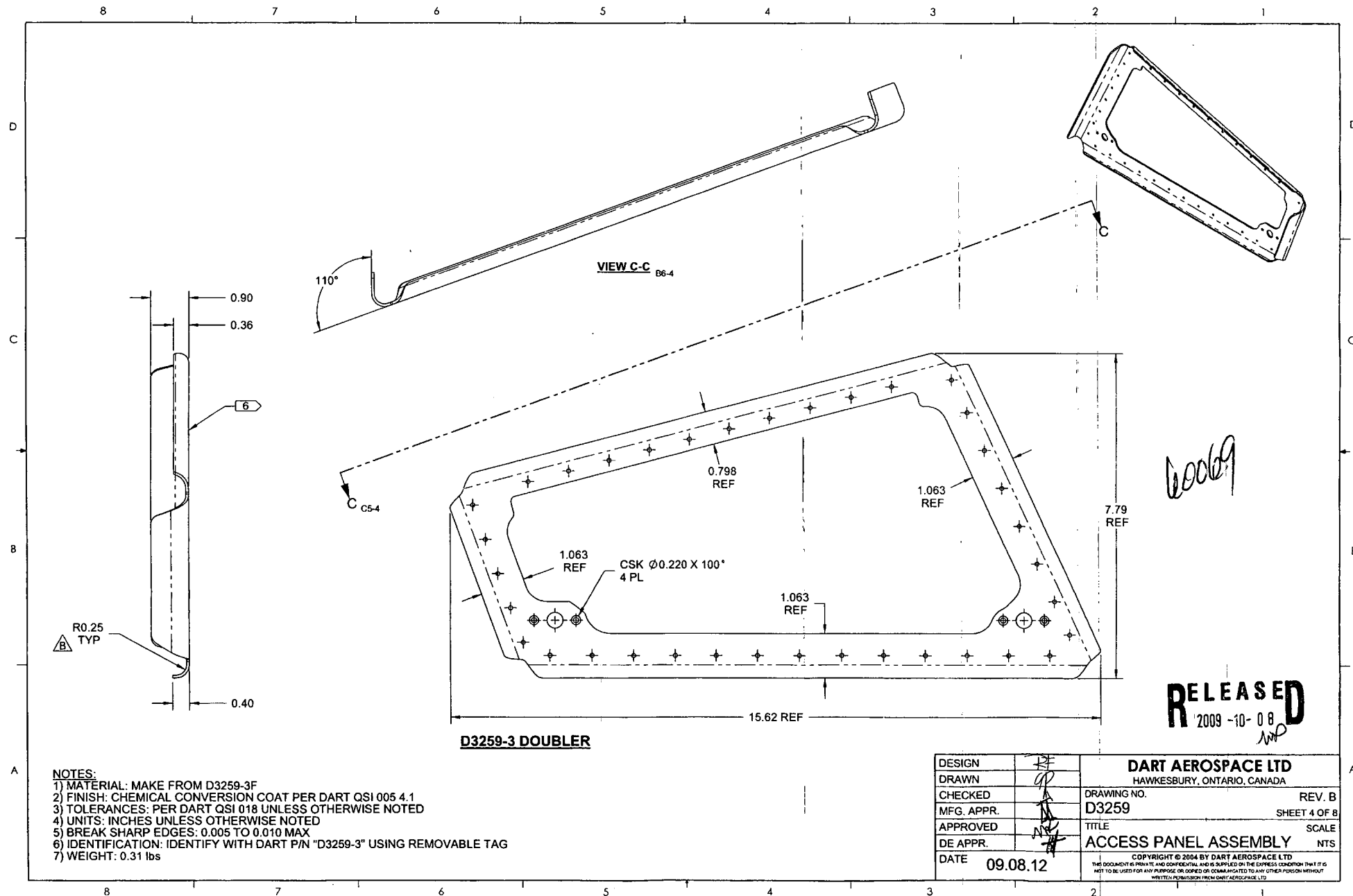
## **NOTES:**

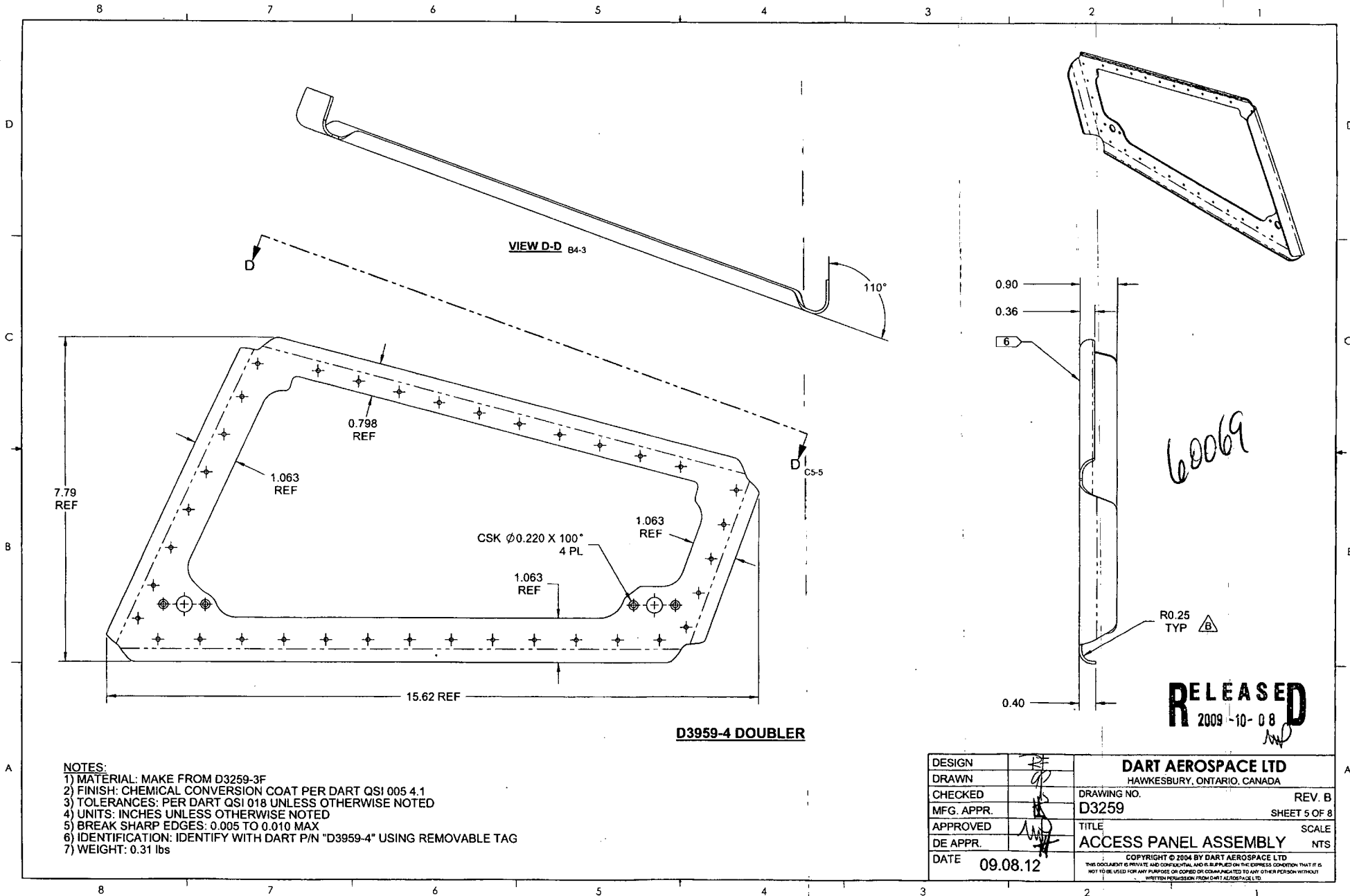
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

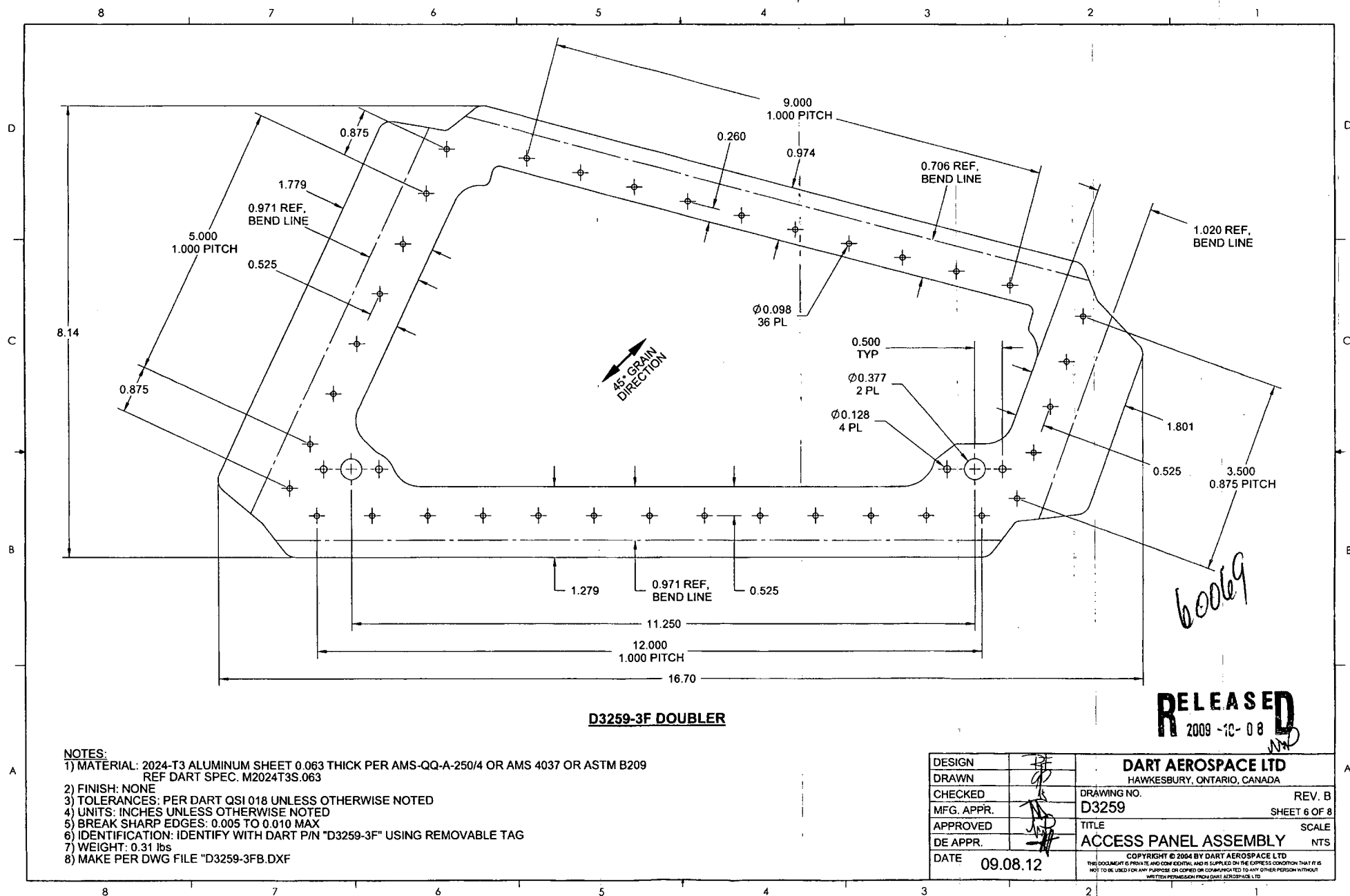
**RELEASED**  
2009-10-08

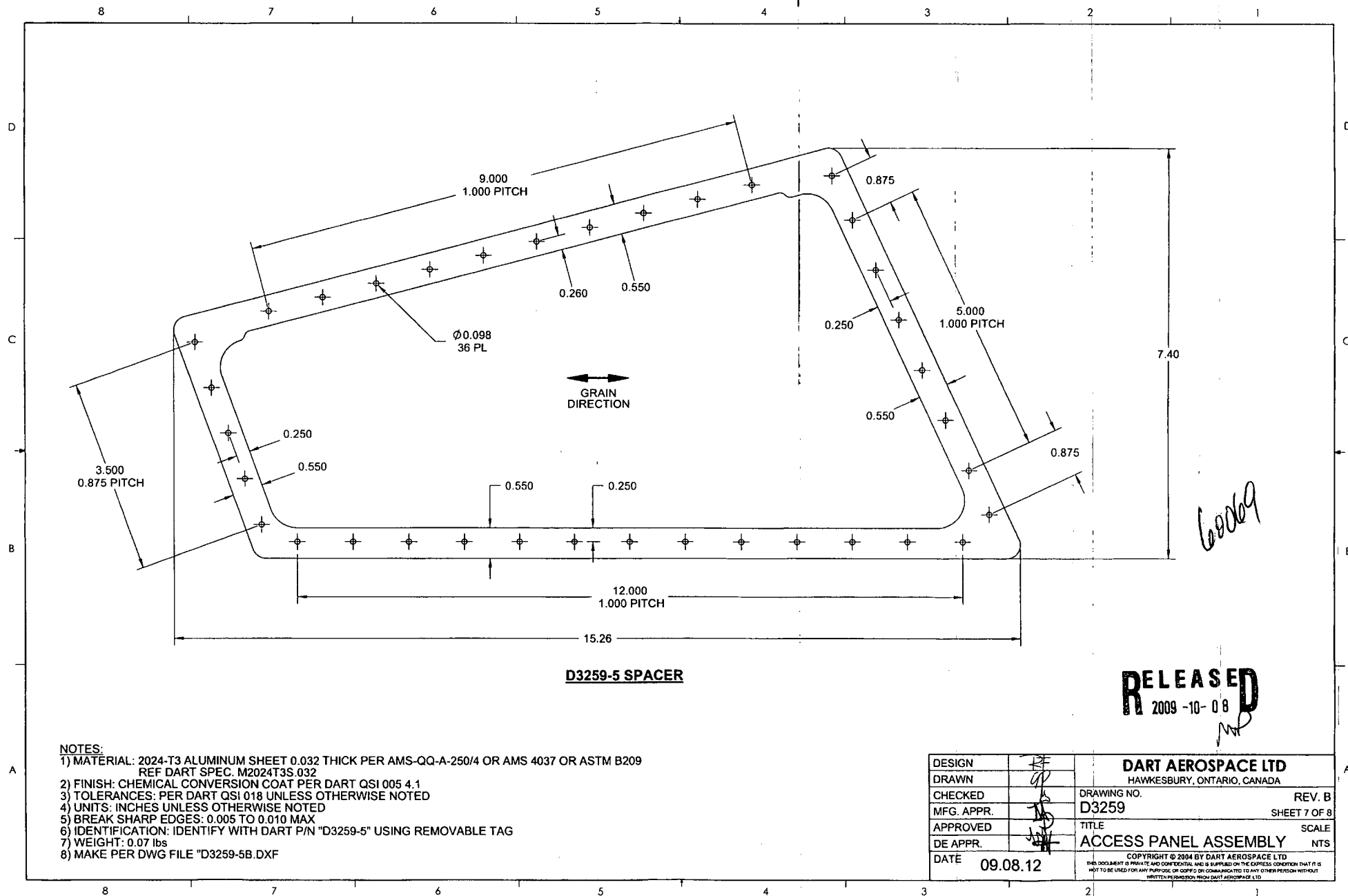
DESIGN	RF	<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3259 SHEET 2 OF 8
APPROVED		TITLE SCALE
DE APPR.		ACCESS PANEL ASSEMBLY NTS
DATE	09.08.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

8 7 6 5 4 3 2 1









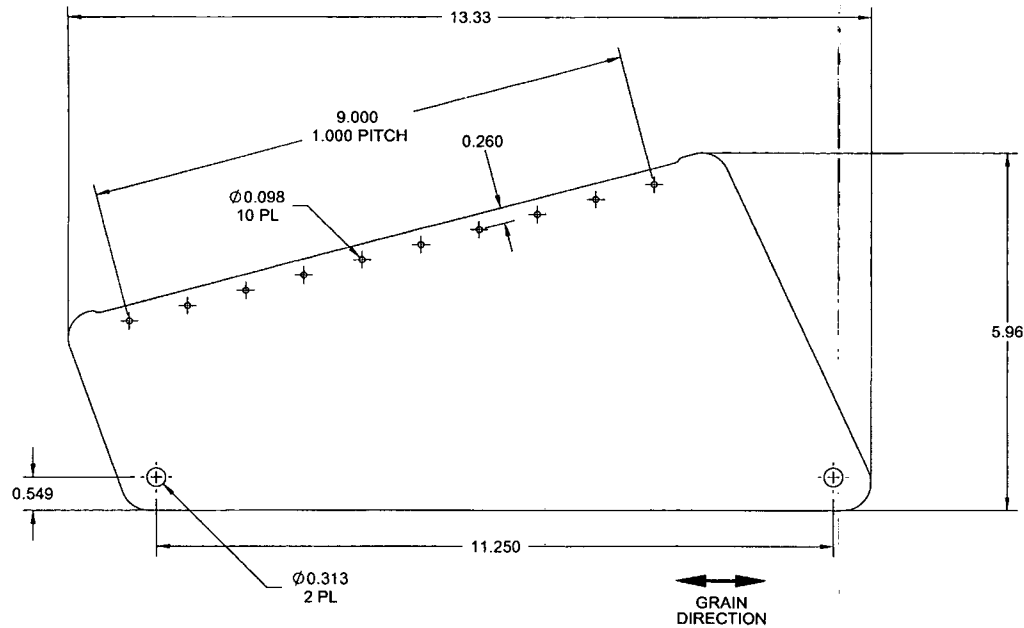
**D3259-5 SPACER**

**RELEASED**  
2009-10-08

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC. M2024T3S 032
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-5" USING REMOVABLE TAG
  - 7) WEIGHT: 0.07 lbs
  - 8) MAKE PER DWG FILE "D3259-5B.DXF"

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	NTS
DATE	09.08.12	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





**D3259-7 DOOR**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D3259	SHEET 8 OF 8
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	ACCESS PANEL ASSEMBLY	NTS
DATE	09.08.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

**RELEASED**  
2009-10-08